



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**PRELIMINARY ISSUE**

**D2940-1**  
**Job Sheet 198490**

Accounting Job SE19-664-14



**Part No:** D2940-1  
**Part Name:** Support

**Job Qty:** 2 pcs

**POSITIVE RECALL**

EFFECTIVE DATE 30 2019 AUTH 27

RELEASED DATE Priority: Medium

**Part Weight:** 0 lbs

**Status:** New

**Job Created:** 7/30/19

**Job Tracking No:**

**Due Date:** 8/27/19

**Created By:** Marie Lajeunesse

**Type:** R+D

**Description:**

**Note:** DWG REV C IPP C 02.11.26 Reformat; Added P/O KJ IPP Rev:D Added priming as per Rev B 07-04-30 JLM  
IPP E 08.03.19 Re-format Ec verified by DD IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G  
11.08.04 as per dwg rev.C DD ver:EC

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation   | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|-------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |             |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 100   | HAAS 4 Axis | 2 pcs | 8/27/19    |          | 0.32      | 4.76    | HAAS - 1              |           |                |
|       |             |       |            |          |           |         | HAAS - 2              |           |                |
|       |             |       |            |          |           |         | HAAS - 3              |           |                |
|       |             |       |            |          |           |         | HAAS - 4              |           |                |
| 110   | QC 2        | 2 pcs | 8/27/19    |          | 0.00      | 0.00    | QC 2 - 1              |           | ALL 2019/08/04 |
|       |             |       |            |          |           |         | QC 2 - 12             |           |                |
|       |             |       |            |          |           |         | QC 2 - 14             |           |                |
|       |             |       |            |          |           |         | QC 2 - 17             |           |                |
|       |             |       |            |          |           |         | QC 2 - 19             |           |                |
|       |             |       |            |          |           |         | QC 2 - 2              |           |                |
|       |             |       |            |          |           |         | QC 2 - 20             |           |                |
|       |             |       |            |          |           |         | QC 2 - 22             |           |                |
|       |             |       |            |          |           |         | QC 2 - 23             |           |                |
|       |             |       |            |          |           |         | QC 2 - 25             |           |                |
|       |             |       |            |          |           |         | QC 2 - 32             |           |                |
|       |             |       |            |          |           |         | QC 2 - 33             |           |                |
|       |             |       |            |          |           |         | QC 2 - 35             |           |                |
|       |             |       |            |          |           |         | QC 2 - 39             |           |                |
|       |             |       |            |          |           |         | QC 2 - 4              |           |                |
|       |             |       |            |          |           |         | QC 2 - 40             |           |                |
|       |             |       |            |          |           |         | QC 2 - 44             |           |                |
|       |             |       |            |          |           |         | QC 2 - 45             |           |                |
|       |             |       |            |          |           |         | QC 2 - 48             |           |                |
|       |             |       |            |          |           |         | QC 2 - 49             |           |                |
|       |             |       |            |          |           |         | QC 2 - 50             |           |                |
|       |             |       |            |          |           |         | QC 2 - 51             |           |                |
|       |             |       |            |          |           |         | QC 2 - 52             |           |                |
|       |             |       |            |          |           |         | QC 2 - 57             |           |                |
|       |             |       |            |          |           |         | QC 2 - 62             |           |                |
|       |             |       |            |          |           |         | QC 2 - 63             |           |                |

DAS  
64  
9-89

PRELIMINARY ISSUE

POSITIVE RESULT

EFFECTIVE AUTH

RELEASED DATE



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Container No: S202708



Part: D2940-1

Job No: 198490

Serial No/Batch: S202708

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/04/19



|                                 |       |         |           |                       |                |
|---------------------------------|-------|---------|-----------|-----------------------|----------------|
| 120 QC 8                        | 2 pcs | 8/27/19 | 0.00 0.00 | QC 2 - 8              |                |
|                                 |       |         |           | QC 2 - 66             |                |
|                                 |       |         |           | QC 2 - 64             | mm 2019/08/04  |
|                                 |       |         |           | QC 2 - 65             |                |
|                                 |       |         |           | QC 2 - 5              |                |
|                                 |       |         |           | QC 2 - 71             |                |
|                                 |       |         |           | QC 2 - 73             |                |
|                                 |       |         |           | QC 2 - 69             |                |
|                                 |       |         |           | QC 8 - 12             |                |
|                                 |       |         |           | QC 8 - 14             |                |
|                                 |       |         |           | QC 8 - 17             |                |
|                                 |       |         |           | QC 8 - 20             |                |
|                                 |       |         |           | QC 8 - 25             |                |
|                                 |       |         |           | QC 8 - 3              |                |
|                                 |       |         |           | QC 8 - 32             |                |
|                                 |       |         |           | QC 8 - 33             |                |
|                                 |       |         |           | QC 8 - 35             |                |
|                                 |       |         |           | QC 8 - 39             |                |
|                                 |       |         |           | QC 8 - 4              |                |
|                                 |       |         |           | QC 8 - 44             |                |
| 130 Crosstubes - 2 - B4B        | 2 pcs | 8/27/19 | 0.00 0.25 | QC 8 - 45             |                |
|                                 |       |         |           | QC 8 - 49             |                |
|                                 |       |         |           | QC 8 - 58             |                |
|                                 |       |         |           | QC 8 - 8              |                |
|                                 |       |         |           | QC 8 - 9              |                |
|                                 |       |         |           | QC 8 - 68             | DAS            |
|                                 |       |         |           | QC 8 - 67             | AUG 07 2019 68 |
|                                 |       |         |           | QC 8 - 1 (A)          | 9-89           |
|                                 |       |         |           | QC 8 - 47             |                |
|                                 |       |         |           | QC 8 - 40             |                |
| 140 QC 5                        | 2 pcs | 8/27/19 | 0.00 0.00 | QC 8 - 52             |                |
|                                 |       |         |           | QC 8 - 23             |                |
|                                 |       |         |           | QC 8 - 57             |                |
|                                 |       |         |           | Crosstubes - 1 - B4B  |                |
|                                 |       |         |           | Crosstubes - 2 - B4B  |                |
|                                 |       |         |           | Crosstubes - 3 - B4B  |                |
|                                 |       |         |           | Crosstubes - 4 - B4B  | 2019-8-27      |
|                                 |       |         |           | QC 5 - 10             |                |
|                                 |       |         |           | QC 5 - 12             |                |
|                                 |       |         |           | QC 5 - 17             |                |
| 170 Packaging 3-1 - Stock - B4B | 2 pcs | 8/27/19 | 0.00 0.00 | QC 5 - 18             |                |
|                                 |       |         |           | QC 5 - 19             |                |
|                                 |       |         |           | QC 5 - 22             |                |
|                                 |       |         |           | QC 5 - 24             |                |
|                                 |       |         |           | QC 5 - 3              |                |
|                                 |       |         |           | QC 5 - 43             |                |
|                                 |       |         |           | QC 5 - 49             |                |
|                                 |       |         |           | QC 5 - 51             |                |
|                                 |       |         |           | QC 5 - 58             |                |
|                                 |       |         |           | QC 5 - 68             |                |
| Eng use only 9/20/20            |       |         |           | QC 5 - 9              |                |
|                                 |       |         |           | QC 5 - 50             |                |
|                                 |       |         |           | QC 5 - 30             |                |
|                                 |       |         |           | QC 5 - 40             |                |
| 170 Packaging 3-1 - Stock - B4B | 2 pcs | 8/27/19 | 0.00 0.00 | QC 5 - 61             |                |
|                                 |       |         |           | QC 5 - 81             |                |
|                                 |       |         |           | Packaging 3 - 1 - B4B |                |
| Eng use only 9/20/20            |       |         |           | Packaging 3 - 2 - B4B |                |
|                                 |       |         |           | Packaging 3 - 3 - B4B |                |
|                                 |       |         |           |                       |                |



|                |       |         |           |                        |  |
|----------------|-------|---------|-----------|------------------------|--|
|                |       |         |           | Packaging 3 - 4 - B4B  |  |
|                |       |         |           | Packaging 3 - 5 - B4B  |  |
|                |       |         |           | Packaging 3 - 6 - B4B  |  |
|                |       |         |           | Packaging 3 - 7 - B4B  |  |
|                |       |         |           | Packaging 3 - 8 - B4B  |  |
|                |       |         |           | Packaging 3 - 9 - B4B  |  |
|                |       |         |           | Packaging 3 - 10 - B4B |  |
|                |       |         |           | Packaging 3 - 11 - B4B |  |
|                |       |         |           | Packaging 3 - 12 - B4B |  |
|                |       |         |           | Packaging 3 - 13 - B4B |  |
|                |       |         |           | Packaging 3 - 14 - B4B |  |
|                |       |         |           | Packaging 3 - 15 - B4B |  |
|                |       |         |           | Packaging 3 - 16 - B4B |  |
|                |       |         |           | Packaging 3 - 17 - B4B |  |
|                |       |         |           | Packaging 3 - 18 - B4B |  |
|                |       |         |           | Packaging 3 - 19 - B4B |  |
|                |       |         |           | Packaging 3 - 20 - B4B |  |
|                |       |         |           | Packaging 3 - 21 - B4B |  |
|                |       |         |           | Packaging 3 - 22 - B4B |  |
|                |       |         |           | Packaging 3 - 23 - B4B |  |
|                |       |         |           | Packaging 3 - 24 - B4B |  |
|                |       |         |           | Packaging 3 - 25 - B4B |  |
|                |       |         |           | Packaging 3 - 26 - B4B |  |
|                |       |         |           | Packaging 3 - 27 - B4B |  |
|                |       |         |           | Packaging 3 - 28 - B4B |  |
|                |       |         |           | Packaging 3 - 29 - B4B |  |
|                |       |         |           | Packaging 3 - 30 - B4B |  |
|                |       |         |           | Packaging 3 - 31 - B4B |  |
|                |       |         |           | Packaging 3 - 32 - B4B |  |
|                |       |         |           | Packaging 3 - 33 - B4B |  |
|                |       |         |           | Packaging 3 - 34 - B4B |  |
|                |       |         |           | Packaging 3 - 35 - B4B |  |
|                |       |         |           | Packaging 3 - 36 - B4B |  |
| 180 QC 21 - SA | 2 pcs | 8/27/19 | 0.00 0.00 | QC 21 - SA - 21        |  |
|                |       |         |           | QC 21 - SA - 70        |  |
|                |       |         |           | QC 21 - SA - 53        |  |

Part Op 100 - 1-Machine as per Folio FA079  
 Descriptions: 110 - (QC8- Inspect parts - second check)  
 120 - (QC8- Inspect parts - second check)  
 130 - Per note 8 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.  
 140 - (QC5- Inspect part completeness to step on W/O)  
 170 - (Identify as per dwg & Stock Location: \_\_\_\_\_) LOCATION : LG052  
 180 - (QC21- Final Inspection - Work Order Release)

5174225

## Job BOM

| Part / Item | Component Name         | Quantity      | Operation       | Container |
|-------------|------------------------|---------------|-----------------|-----------|
| DSK081      | D2940-1 Turning Detail | 1 pcs (.5 ea) | 100-HAAS 4 Axis |           |

## Job Allocations

| Operation       | Component Part | Required | Inventory | Allocated |
|-----------------|----------------|----------|-----------|-----------|
| 100-HAAS 4 Axis | DSK081         | 1        | 2         | 0         |



| Part Specifications |               |                                     |                    |      |                  |
|---------------------|---------------|-------------------------------------|--------------------|------|------------------|
| Spec No             | Description   | Target/Tolerance                    | Limits             | Type | Special Comments |
| 1                   | 3.250 Support | 0.240Inches<br>+ 0.020<br>- 0.000   | 0.260<br>0.240     |      |                  |
| 2                   | 3.250 Support | 0.490Inches<br>+ 0.020<br>- 0.000   | 0.510<br>0.490     |      |                  |
| 3                   | 3.250 Support | 0.140Inches<br>+ 0.020<br>- 0.000   | 0.160<br>0.140     |      |                  |
| 4                   | 3.250 Support | 3.510Inches<br>+ 0.020<br>- 0.000   | 3.530<br>3.510     |      |                  |
| 5                   | 3.250 Support | 1.633Inches<br>+ 0.040<br>- 0.000   | 1.673<br>1.633     |      |                  |
| 6                   | 3.250 Support | 1.493Inches<br>+ 0.020<br>- 0.000   | 1.513<br>1.493     |      |                  |
| 7                   | 3.250 Support | 0.040Inches<br>+ 0.020<br>- 0.000   | 0.060<br>0.040     |      |                  |
| 8                   | 3.250 Support | 0.188Inches<br>+ 0.005<br>- 0.000   | 0.193<br>0.188     |      |                  |
| 9                   | 3.250 Support | 0.140Inches<br>+ 0.020<br>- 0.000   | 0.160<br>0.140     |      |                  |
| 10                  | 3.250 Support | 2.518Inches<br>+ 0.020<br>- 0.000   | 2.538<br>2.518     |      |                  |
| 11                  | 3.250 Support | 0.040Inches<br>+ 0.020<br>- 0.000   | 0.060<br>0.040     |      |                  |
| 12                  | 3.250 Support | 0.010Inches<br>+ 0.010<br>- 0.000   | 0.020<br>0.010     |      |                  |
| 13                  | 3.250 Support | 0.140Inches<br>+ 0.020<br>- 0.000   | 0.160<br>0.140     |      |                  |
| 14                  | 3.250 Support | 0.350Inches<br>+ 0.100<br>- 0.000   | 0.450<br>0.350     |      |                  |
| 15                  | 3.250 Support | 0.240Inches<br>+ 0.020<br>- 0.000   | 0.260<br>0.240     |      |                  |
| 16                  | 3.250 Support | 0.150Inches<br>+ 0.020<br>- 0.000   | 0.170<br>0.150     |      |                  |
| 17                  | 3.250 Support | 0.053Inches<br>+ 0.020<br>- 0.000   | 0.073<br>0.053     |      |                  |
| 18                  | 3.250 Support | 101.640Inches<br>+ 4.000<br>- 0.000 | 105.640<br>101.640 |      |                  |
| 19                  | 3.250 Support | 0.260Inches<br>+ 0.007<br>- 0.000   | 0.267<br>0.260     |      |                  |
| 20                  | 3.250 Support | 0.053Inches<br>+ 0.020<br>- 0.000   | 0.073<br>0.053     |      |                  |
| 21                  | 3.250 Support | 4.118Inches<br>+ 0.020<br>- 0.000   | 4.138<br>4.118     |      |                  |

Plex 7/30/19 11:01 AM Dart.lajeunesse.marie



|                           |             |             |             |                     |             |
|---------------------------|-------------|-------------|-------------|---------------------|-------------|
| <b>DART AEROSPACE LTD</b> |             |             |             | <b>Work Order:</b>  | 195490      |
| <b>Description:</b>       |             |             |             | <b>Part Number:</b> |             |
| <b>Inspection Dwg:</b>    | <b>Rev:</b> | <b>DSK:</b> | <b>Rev:</b> |                     |             |
|                           |             |             |             |                     | Page 1 of 1 |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

|               |       |       |                | Record Actual Dimensions |   |   |   |   |
|---------------|-------|-------|----------------|--------------------------|---|---|---|---|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                        | 2 | 3 | 4 | 5 |
| A             | 1.648 | 1.668 |                | 1.662                    |   |   |   |   |
| B             | .142  | .163  |                | .157                     |   |   |   |   |
| C             | 1.493 | 1.525 |                | 1.505                    |   |   |   |   |
| D             | 2.510 | 2.520 |                | 2.522                    |   |   |   |   |
| E             | 1.403 | 1.423 |                | 1.410                    |   |   |   |   |
| F             | .350  | .450  |                | .370                     |   |   |   |   |
| G             | .140  | .190  |                | .168                     |   |   |   |   |
| H             | .040  | .060  |                | .047                     |   |   |   |   |
| I             | .188  | .193  |                | .188                     |   |   |   |   |
| J             | .260  | .267  |                | .260                     |   |   |   |   |
| K             | 4.936 | 4.990 |                | 4.957                    |   |   |   |   |
| L             | .140  | .180  |                | .162                     |   |   |   |   |
| M             | 2.322 | 2.342 |                | 2.335                    |   |   |   |   |
| N             | .718  | .738  |                | .727                     |   |   |   |   |
| O             | .090  | .110  |                | .098                     |   |   |   |   |
| P             | .050  | .070  |                | .060                     |   |   |   |   |
| Q             |       |       |                |                          |   |   |   |   |
| R             |       |       |                |                          |   |   |   |   |
| S             |       |       |                |                          |   |   |   |   |
| T             |       |       |                |                          |   |   |   |   |
| U             |       |       |                |                          |   |   |   |   |
| V             |       |       |                |                          |   |   |   |   |
| W             |       |       |                |                          |   |   |   |   |
| X             |       |       |                |                          |   |   |   |   |
| Y             |       |       |                |                          |   |   |   |   |
| Z             |       |       |                |                          |   |   |   |   |
| AA            |       |       |                |                          |   |   |   |   |
| AB            |       |       |                |                          |   |   |   |   |
| AC            |       |       |                |                          |   |   |   |   |
| AD            |       |       |                |                          |   |   |   |   |
| AE            |       |       |                |                          |   |   |   |   |
| AF            |       |       |                |                          |   |   |   |   |
| AG            |       |       |                |                          |   |   |   |   |
| AH            |       |       |                |                          |   |   |   |   |
| Accept/Reject |       |       |                |                          |   |   |   |   |

|                              |      |             |              |            |
|------------------------------|------|-------------|--------------|------------|
| <b>Measured by:</b>          | M.M. | <b>DAS</b>  | <b>Date:</b> | 2019/08/04 |
| <b>Audited by:</b>           |      | <b>64</b>   | <b>Date:</b> |            |
| <b>Preliminary Approval:</b> |      | <b>9-89</b> | <b>Date:</b> |            |

| Rev | Date     | Change                           | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A   | 02.12.12 | New Issue                        | KJ/RF      |          |
| B   | 07.11.08 | Reformat                         | KJ/JLM     |          |
| C   | 12.07.31 | Prototype revised to preliminary | KJ         |          |

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



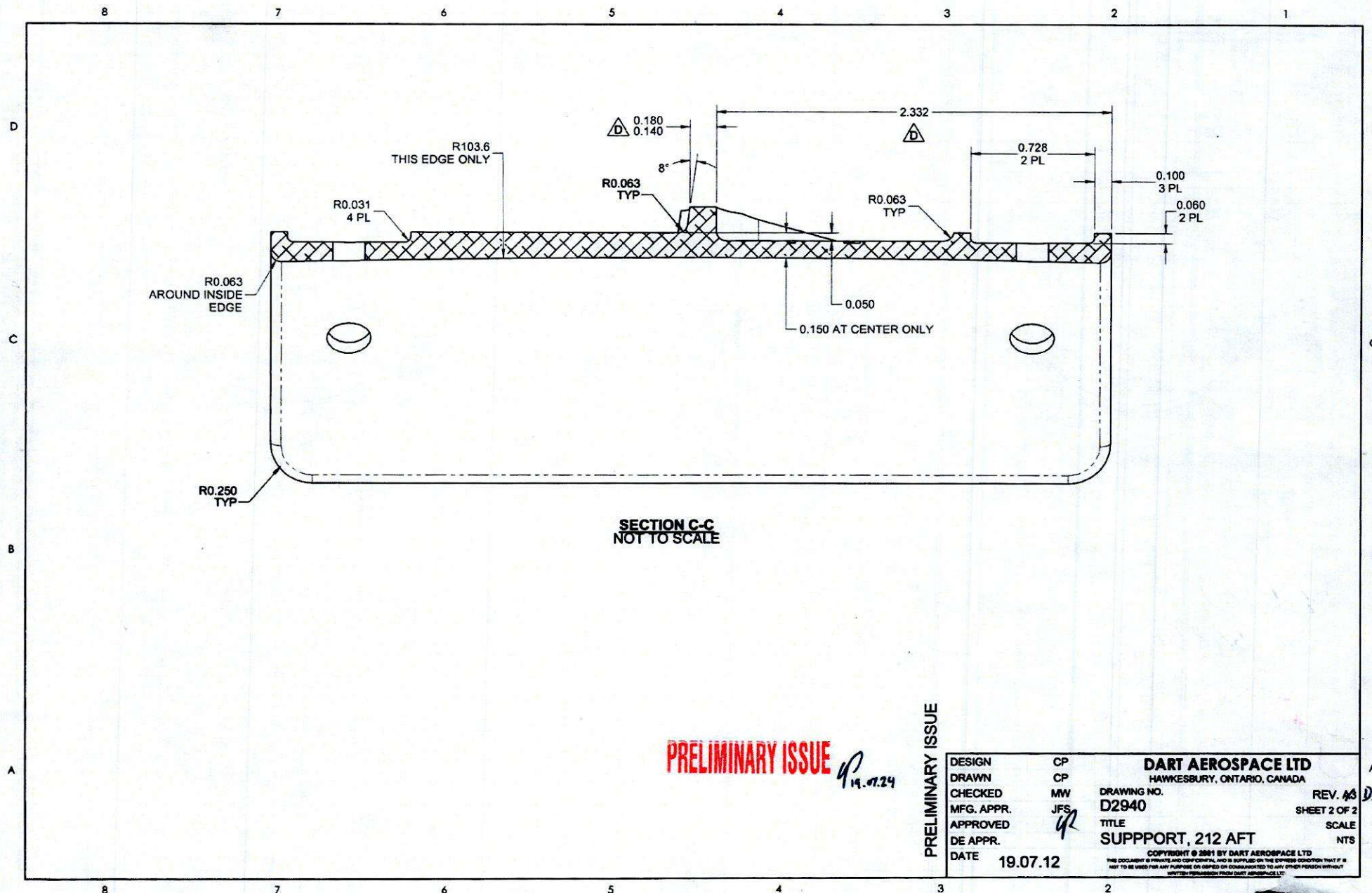
## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

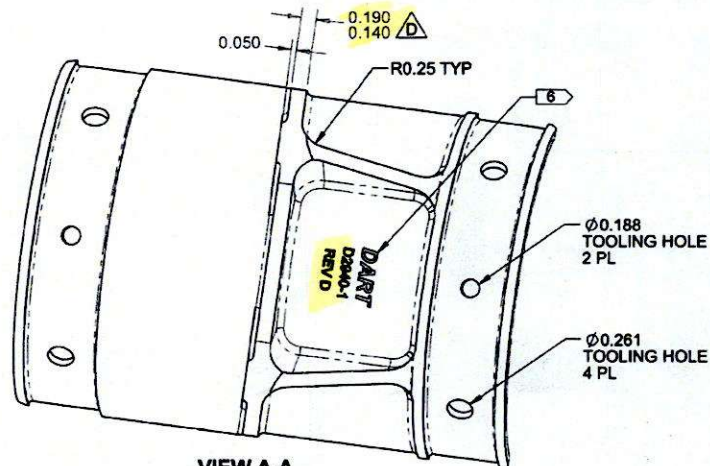
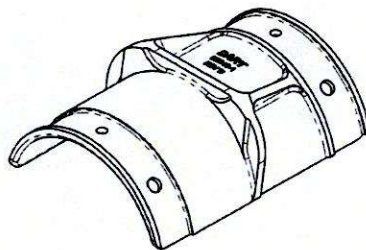
Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                      |  |                        |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Sequence #: _____                                                                                                                 | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
| <b>Root Cause</b><br><br><div style="display: flex;"> <div style="flex: 1;">           Operator <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Presservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div style="flex: 1;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex;"> <div style="flex: 1;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="flex: 1;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="flex: 1;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |



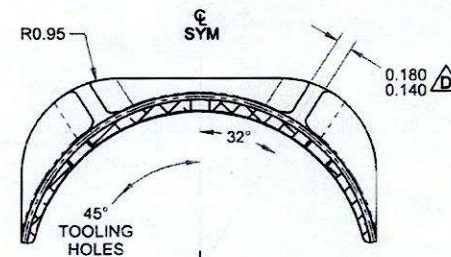
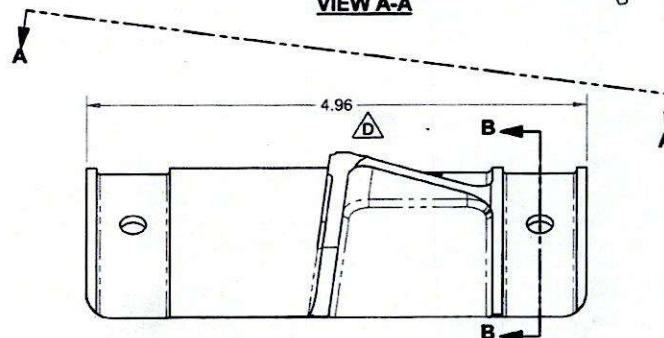
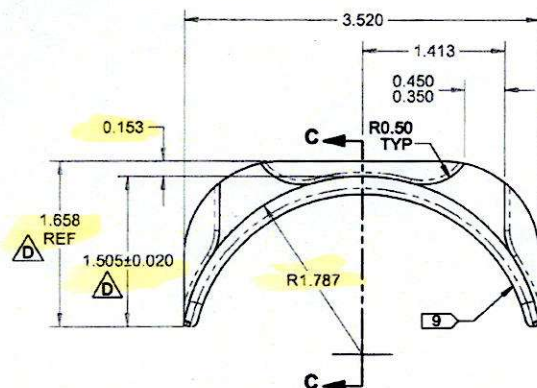






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WORK ORDER  
NO. 198490 MW  
1907-30

VIEW A-A



SECTION B-B

D2940-1 SUPPORT, 212 AFT

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL, H900 OR H925 CONDITION  
MIN UTS = 170 KSI (38 HRc)  
(REF DART SPEC D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO, PART NUMBER, AND REVISION IN THIS AREA WITH 0.125 HIGH LETTERING  
0.010-0.020 DEEP WITH MIN TOOL RAD OF 0.010 PER DART QSI 044 6.3
- 7) WEIGHT: 0.87 lbs
- 8) MACHINE INNER CONCAVE PROFILE AND NON-DIMENSIONED FEATURES PER D2940-1-REV'D STEP
- 9) FOR THE ENTIRE INNER CONCAVE SURFACE: ABRASE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK  
(OR EQUIVALENT). APPLY 0.03" THICK LAYER OF 3M SCOTCH-WEELD 2216 B/A ADHESIVE TO MATING SURFACE OF  
SUPPORT. ALLOW TO CURE FOR 24 HOURS.

PRELIMINARY ISSUE

Rev. P23 PD3

19.07.12

PRELIMINARY ISSUE

| D          | REDRAW IN SW, CHG INNER SURFACE PROFILE, ADD REV TO TEXT, 3M 2216 NOW 0.030 THICK, DIMS AS MFD | CP | 19.07.12 |
|------------|------------------------------------------------------------------------------------------------|----|----------|
| C          | RMV FINISH, ADD EM 2216, ADD H925 MAT'L OPTION                                                 | CP | 11.07.15 |
| B          | UPDATE PER NCR 642, PRIME INSIDE                                                               | PH | 07.03.13 |
| A          | NEW ISSUE                                                                                      | CP | 01.01.10 |
| REV.       | DESCRIPTION                                                                                    | BY | DATE     |
| DESIGN     | CP                                                                                             |    |          |
| DRAWN      | CP                                                                                             |    |          |
| CHECKED    | MW                                                                                             |    |          |
| MFG. APPR. | JFS                                                                                            |    |          |
| APPROVED   |                                                                                                |    |          |
| DE APPR.   |                                                                                                |    |          |
| DATE       | 19.07.12                                                                                       |    |          |

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
D2940

TITLE  
SUPPT, 212 AFT

REV. 13  
SHEET 1 OF 2

SCALE  
NTS

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|                                    |                      |                             |
|------------------------------------|----------------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>          |                      | <b>Work Order:</b> 198490   |
| <b>Description:</b> Ø3.250 Support |                      | <b>Part Number:</b> D2940-1 |
| <b>Inspection Dwg:</b> D2940       | <b>Rev:</b> <u>2</u> | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

|               |        |        |                | Record Actual Dimensions |             |   |   |   |
|---------------|--------|--------|----------------|--------------------------|-------------|---|---|---|
| Dim           | Min    | Max    | Go/No Go Gauge | 1                        | 2           | 3 | 4 | 5 |
| HAAS Section  |        |        |                |                          |             |   |   |   |
| AA            | 0.240  | 0.260  |                | R.250 OK                 | R.250 OK    |   |   |   |
| AB            | 0.490  | 0.510  |                | R.500 OK                 | R.500 OK    |   |   |   |
| AC            | 0.140  | 0.160  |                | .150 / .166              | .150 / .166 |   |   |   |
| AD            | 3.510  | 3.530  |                | 3.522                    | 3.522       |   |   |   |
| AE            | 1.633  | 1.673  |                | 1.662                    | 1.661       |   |   |   |
| AF            | 1.493  | 1.513  |                | 1.505                    | 1.504       |   |   |   |
| AG            | 0.040  | 0.060  |                | .047                     | .046        |   |   |   |
| AH            | 0.188  | 0.193  |                | .188 Ø                   | .188 Ø      |   |   |   |
| AI            | 0.140  | 0.160  |                | .151                     | .152        |   |   |   |
| AJ            | 2.518  | 2.538  |                | 2.537                    | 2.538       |   |   |   |
| AK            | 0.040  | 0.060  |                | .050                     | .050        |   |   |   |
| AL            | 0.010  | 0.020  |                | .010                     | .010        |   |   |   |
| AM            | 0.140  | 0.160  |                | .160                     | .160        |   |   |   |
| AN            | 0.350  | 0.450  |                | .366                     | .365        |   |   |   |
| AO            | 0.240  | 0.260  |                | R.250 OK                 | R.250 OK    |   |   |   |
| AP            | 0.150  | 0.170  |                | .158                     | .158        |   |   |   |
| AQ            | 0.053  | 0.073  |                | R.063 OK                 | R.063 OK    |   |   |   |
| AR            | 101.64 | 105.64 |                | 102.00                   | 102.00      |   |   |   |
| AS            | 0.260  | 0.267  |                | .260 Ø                   | .260 Ø      |   |   |   |
| AT            | 0.053  | 0.073  |                | R.063 OK                 | R.063 OK    |   |   |   |
| AU            | 4.118  | 4.138  |                | 4.125                    | 4.125       |   |   |   |
| AV            |        |        |                |                          |             |   |   |   |
| AW            |        |        |                |                          |             |   |   |   |
| Accept/Reject |        |        |                |                          |             |   |   |   |

|                               |                         |
|-------------------------------|-------------------------|
| <b>Measured by:</b> <u>mm</u> | <b>Date:</b> 2019/08/04 |
| <b>Audited by:</b>            | <b>Date:</b>            |
| <b>Prototype Approval:</b>    | <b>Date:</b>            |

| Rev | Date     | Change               | Revised by | Approved |
|-----|----------|----------------------|------------|----------|
| A   | 02.12.12 | New Issue            | KJ/RF      |          |
| B   | 07.05.08 | Dwg Rev. updated     | KJ/JLM     |          |
| C   | 07.07.18 | Dimension AS revised | KJ/JLM     |          |
| D   | 08.04.22 | Reformat             | KJ/JLM     |          |
| E   | 12.01.31 | Dwg Rev. updated     | KJ         |          |